



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3913-041
Job Sheet 168954



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/27/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/4/18	0.00	0.00	Start Up Large Fab-2		DL 2018-01-29
100	Large Fab	1 pcs		1/4/18	0.00	10.00	Large Fab 1		C 2018-02-01
110	QC	1 pcs		1/4/18	0.00	0.00	QC9		PD 18-2-2
120	QC	1 pcs		1/4/18	0.00	0.00	QC5		PD 18-2-2
125	HandFinish	1 pcs		1/4/18	0.00	0.29	HandFinish2		2018/02/06 JLM
130	Powdercoat	1 pcs		1/4/18	0.00	0.93	Powdercoat2		BL 18-02-6
135	Packaging	1 pcs		1/4/18	0.00	0.00	Packaging1		HL 18-02-07
140	QC	1 pcs		1/4/18	0.00	0.00	QC3		BEB 18-02-07
150	HandFinish	1 pcs		1/5/18	0.00	0.50	HandFinish4		BGB 18-02-07
160	QC	1 pcs		1/5/18	0.00	0.00	QC5		38
170	Packaging	1 pcs		1/5/18	0.00	0.00	Packaging3		BEB 18-02-07
180	QC21-SA	1 Ea		1/5/18	0.00	0.00	QC21		21 FEB 07 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138467. START: 2:50. O.V. T: 375°. FINISH: 3:05.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581	2	77	0	0
	D3913-15032741	1	6	0	0
	D3913-15014390	1	2	0	0
	D3913-35018474	1	9	0	0
	D3913-75009710	2	23	0	0
	D3913-95030824	1	15	0	0
	D3916-041	2	2	0	0
	D3916-55026219x2	2	19	0	0
	D4016-12034748	3	44	0	0
	D4017-75031312	3	51	0	0
	D4017-95009723	2	24	0	0
	D4020-115016763	2	6	0	0
	D4021-15010955	3	55	0	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

150-HandFinish	5030325	D4034-041	5032895	1	2	0	0
		D4034-043		1	2	0	0
		D4672-1	5005866	2	41	0	0
	5021100	M304EX0.75-16F		33	572	0	0
	ST 349	AN3-10A	5000660	6	178	0	0
	ST 013	D2931	F86435-1	2	1,200	0	0
	ST 068	D4021-55	5021383	2	9	0	0
	ST 308	MS20600-AD4W3	5019431	2	177	0	0
	ST 303	MS21042L3	5037284-1	6	908	0	0
	ST 262	NAS1149F0332P	5020603	12	2,453	0	0

Part Specifications

Specifications could not be found.

Plex 11/27/17 2:30 PM dart.poulin.mario

000186

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	 S036511 Long Basket Base Assembly, 350	PART NO: D3913-041 Original Serial #: S036511 Revision: Operation: Start up Operation 01/29/18 Change No:	Job No: 168954	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
				ework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
				Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
				Re-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
				Improved ☐	Large Fab ☐	Composite ☐	Supplier ☐			
				QTY Effective :			MRB (QSI042) Approval			
				Disposition			Completed By			
							Lead hand / Supervisor Approval Verification			

Substation		Process Improvement	Marks/Chatter
Past Expiry Date		Manufacturing Process	
Misidentified		Past Due	OTHER :

Master Unit 000186	Job No 168954
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